

Work Order ID 158160***158160***

Page 1

Monday, March 13, 2017 10:45:15 AM

Item ID: D2366 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lock Handle
Start Date: 3/14/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 3/23/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference: SCHEDULE/S

Approvals: Process Plan: DAS Date: MAR 13 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2366	Rev C								

100

0.00

100

FLOW WATER JET

0.03

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg 2366 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary6 PR 17/03/14

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.01

QC

Memo

Quality Control

6 PR 17/03/14

120

0.00

120

QC8- Inspect parts - second check

0.02

QC

Memo

Quality Control

6 PR 17/03/14
DAS
38
2-89
MAR 15 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					(6)			02/17/23/17
Small Fab	Memo	0.01							
Small Fab	Tumble and stock								
140		0.00							
140	Identify as per dwg & Stock Location: <u>Stoob</u>					6			
Packaging	Memo	0.01							
Packaging									MAR 17 2017
150		0.00							
150	QC21- Final Inspection - Work Order Release								
QC	Memo	0.10							17/3/21 JF
Quality Control									

DAS
21
9-88

MAR 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Monday, March 13, 2017 10:45:14 AM

Page 1

Work Order ID: 158160

158160

Parent Item: D2366

D2366

Parent Item Name: Lock Handle

Start Date: 3/14/2017

Required Date: 3/23/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B00.05.04ReformatEC
IPP Rev:C Now on Waterjet 07-04-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	150.4110	0.0174	0.109895			

M304S20GA

304/316 .040 Sheet

PR 17/03/14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	149.59	
m134495	0.2	
m134982	0.1	
m135327	2	
<u>m135689</u>	1.44	<u>0.11</u>
m136327	25.05	
m136568	56.8	
m137041	64	
MAT20	0.821	
m133901	0.821	

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order:	158160
Description: Lock Handle		Part Number:	D2366
Inspection Dwg: D2366	Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

Prototype

[illegible]

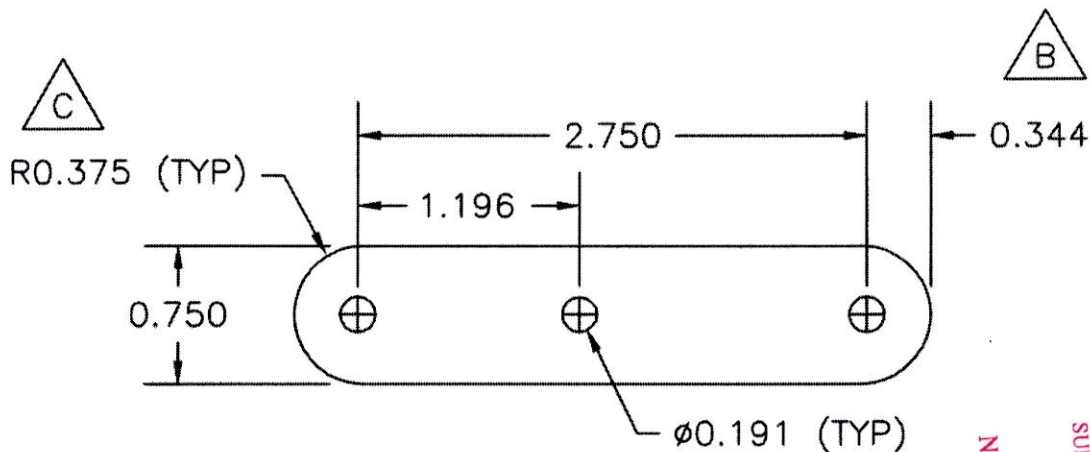
Measured by:	PR	Audited by:	DAS 38	Prototype Approval:	N/A
Date:	17/03/14	Date:	9-89 MAR 15 2017	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD 	



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2366	REV. C SHEET 1 OF 1
DATE 00.04.24		TITLE LOCK HANDLE	SCALE 1:1
A	95.02.20	NEW ISSUE	
B	96.06.10	R0.50 WAS R0.354; 0.344 WAS 0.300	
C	00.04.24	R0.375 WAS R0.50	

RELEASED
00.05.02 #



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 158160 M-5
17-03-13

MATERIAL: AISI 304/316 SS 0.040 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSION ARE INCHES

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